

Work Order ID 144847

April 26, 2016 10:42:53 AM

144847

Page 1

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 5/6/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 5/31/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: SLA - D350 160426 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	Document Control	0.00	69-6						
100	DOCUMENT CONTROL	MAY 14 2016	9						
DC	Memo	0.00	9-89						
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								
110	Large Fab	0.00							
110									
Large Fab	Memo	3.20							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>m134442/m131562</u>								
	3-Grind End Plate flush <u>16-5-10</u>								

B144847 (x10 LH)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

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Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : ☐																																																																				

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Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-89

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.10

Quality Control

180

0.00

180

Large Fab

2.80

Large Fab

Memo

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI.004 & Dwg D3272

A/R Aluminum Rod m23442 m231562

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10 ~~✓~~ BE16-05-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC10- Inspect visual per QSI004- ground welds

0,00

190

OC

Memo

0.00

Quality Control

MAY 17 2016

200

QC5- Inspect part completeness to step on W/O

0.00

200

OC

Memo

0.20

Quality Control

MAY 17 2016

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.70

Hand Finishing

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 144847

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144847

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 5/6/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 5/31/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220	<i>m 134631</i>								
Powdercoat	Memo	1.70							
Powder Coating	START TIME: <i>11:45</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>12:10</i>								
									<i>10. 16-05-19 233</i>
230	Wing Walk as per dwg QSI005 4.4 Batch <i>11134487</i>	0.00							
230									
HandFinish	Memo	1.90							
Hand Finishing									<i>x1064 16/05/19</i>
240	QC3- Inspect Part Finish	0.00							
240									
QC	Memo	0.10							
Quality Control									<i>(10)</i>

DAS
38
9-88

MAY 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : ☐																									

Work Order ID 144847

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144847

Page 7

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 5/6/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 5/31/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280 QC	Memo	1.00							
Quality Control									

MW
MAY 26 2016
MW MAY 26 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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144847

D350-591-311

Required Date: 5/31/2016

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 *D3272-1* Step		Manufactured	No			110	Each	2.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		2							
				140462		2							
D3067-1 *D3067-1* End Plate		Manufactured	No			110	Each	77.0000	1	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		77							
				142780		77							
D3219-1 *D3219-1* Plate		Manufactured	No			110	Each	120.0000	2	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		120							
				142668		40							
				144410		80							
D3066-1 *D3066-1* Spacer		Manufactured	No			180	Each	32.0000	2	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		32							
				142788		32							

Picklist Print

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Page 2

Work Order ID: 144847

144847

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 5/6/2016

Required Date: 5/31/2016

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

1,604.000

16

160

MS20600-AD4W4

Rivets

**

BE 16-05-16
B M133694 x160

Location

Loc Qty

Loc Code

CCK005

1482

M133990

1482

ST308

122

M132640

122

D3065-041

Manufactured

No

180

Each

11.0000

1

10

D3065-041

Step Leg Assembly

**

BE 16-05-13
B 144982 x10

Location

Loc Qty

Loc Code

WA002

11

144118

11

D3067-1

Manufactured

No

180

Each

77.0000

1

10

D3067-1

End Plate

**

BE 16-05-16

Location

Loc Qty

Loc Code

WA003

77

142780

77

AN3-35A

Purchased

No

250

Each

199.0000

2

20

AN3-35A

Bolt

**

88-6
82
DAG
6
8-89
SWD

MAY 14 2016

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

189

m134167

50

m134497

139

27
28

30

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Work Order ID: 144847

144847

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 5/6/2016

Required Date: 5/31/2016

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Manufactured No

250

Each

102.0000

2

20

D3235-1

Mounting Lug

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

ST521

2

141693

2

ST546A

100

143809

100

D3278-041

Manufactured No

250

Each

24.0000

1

10

D3278-041

Support Assembly

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

ST522

24

140959

4

142673

20

NAS1149D0463J

Purchased

No

250

Each

3,166.000

16

160

NAS1149D0463.J

WASHER

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

GA

328

M132035

21

M134508

307

ST260a

1600

M134508

600

M134634

1000

ST263

250

M134039

29

M134573

221

ST269

988

M132317

100

M132677

888

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Work Order ID: 144847

144847

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 5/6/2016

Required Date: 5/31/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased No

250 Each

1,398.000 4 40

NAS1149D0563J

Washer

**

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

261

m125807

2

m133769

259

ST263

1038

m134257

38

m134497

1000

ST269

99

m128257

99

70

AN5-36A

Purchased No

250 Each

89.0000 2 20

AN5-36A

Bolt

**

DAS
6
9-89

68-6
28
9-89

Location

Loc Qty

Loc Code

over004

40

M134509

40

ST336

49

M130466

15

M134502

34

20

D2618

Manufactured No

250 Each

19.0000 2 20

D2618

Bushing

**

144670

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008A

19

141571

19

DAS
27
9-89

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Work Order ID: 144847

144847

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 5/6/2016

Required Date: 5/31/2016

Start Qty: 10.00

Required Qty: 10.00

D2230-3 Manufactured No 250 Each 101.0000 4 40

D2230-3

Mounting Lug

**

DAS 6 28
9-89 9-89

142522

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	8	
109344	4	
89045	4	
ST521	93	
141406	93	

D2856-400-720 Manufactured No 250 Each 52.0000 2 20

D2856-400-720

Abrasion Strip 4" X 7.20"

**

DAS 6 28
9-89 9-89

134509 X 7 9.22
141123 X 13 2.8

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	19	
134509	4	
137049	15	
ST418	33	
141946	33	

MS21042L3 Purchased No 250 Each 2,101.000 2 20

MS21042L3

Nut

**

DAS 6 28
9-89 9-89

142522

DAS
27
9-89

Location	Loc Qty	Loc Code
FP001	100	
m133790	100	
GA	761	
m133790	3	
m134360	758	
ST303	1240	
m134039	12	
m134360	628	
m134634	600	

20

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Work Order ID: 144847

144847

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 5/6/2016

Required Date: 5/31/2016

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

482.0000

8

80

AN4-13A

Bolt

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

36

m134167

36

over003

300

m134634

300

ST344

126

m134260

9

m134497

117

MS21042L5

Purchased

No

250

Each

451.0000

2

20

MS21042L5

Nut

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

GA

115

m127813

115

OVER007

100

m134509

100

ST303

236

m134055

11

m134567

225

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Work Order ID: 144847

144847

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 5/6/2016

Required Date: 5/31/2016

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

1,642.000

8

80

MS21042L4

Locknut

**

DAS

68-6

6

82

9-89

SV

Location

Loc Qty

Loc Code

GA

283

m133769

283

ST303

1262

m134055

1

m134509

261

m134606

1000

ST305

97

m130922

97

NAS1149D0363J

Purchased

No

250

Each

1,518.000

4

40

NAS1149D0363J

Washer

**

DAS

9

DAS 9

6

9-89

Location

Loc Qty

Loc Code

GA

518

m134055

518

ST263

1000

m134370

19

m134606

981

DAS

6

9-89

MAY 14 2016



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

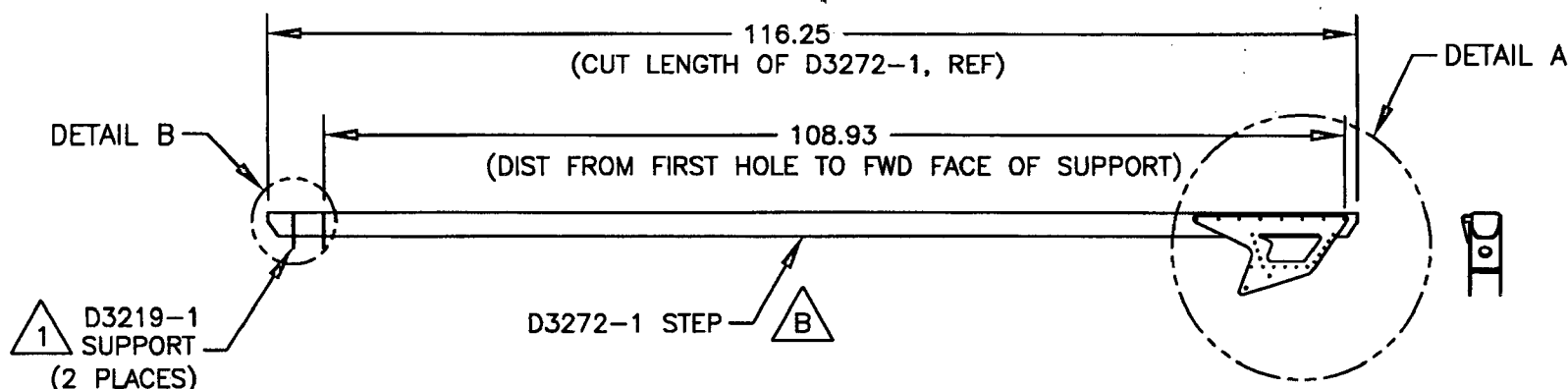
20160426
SH 144847

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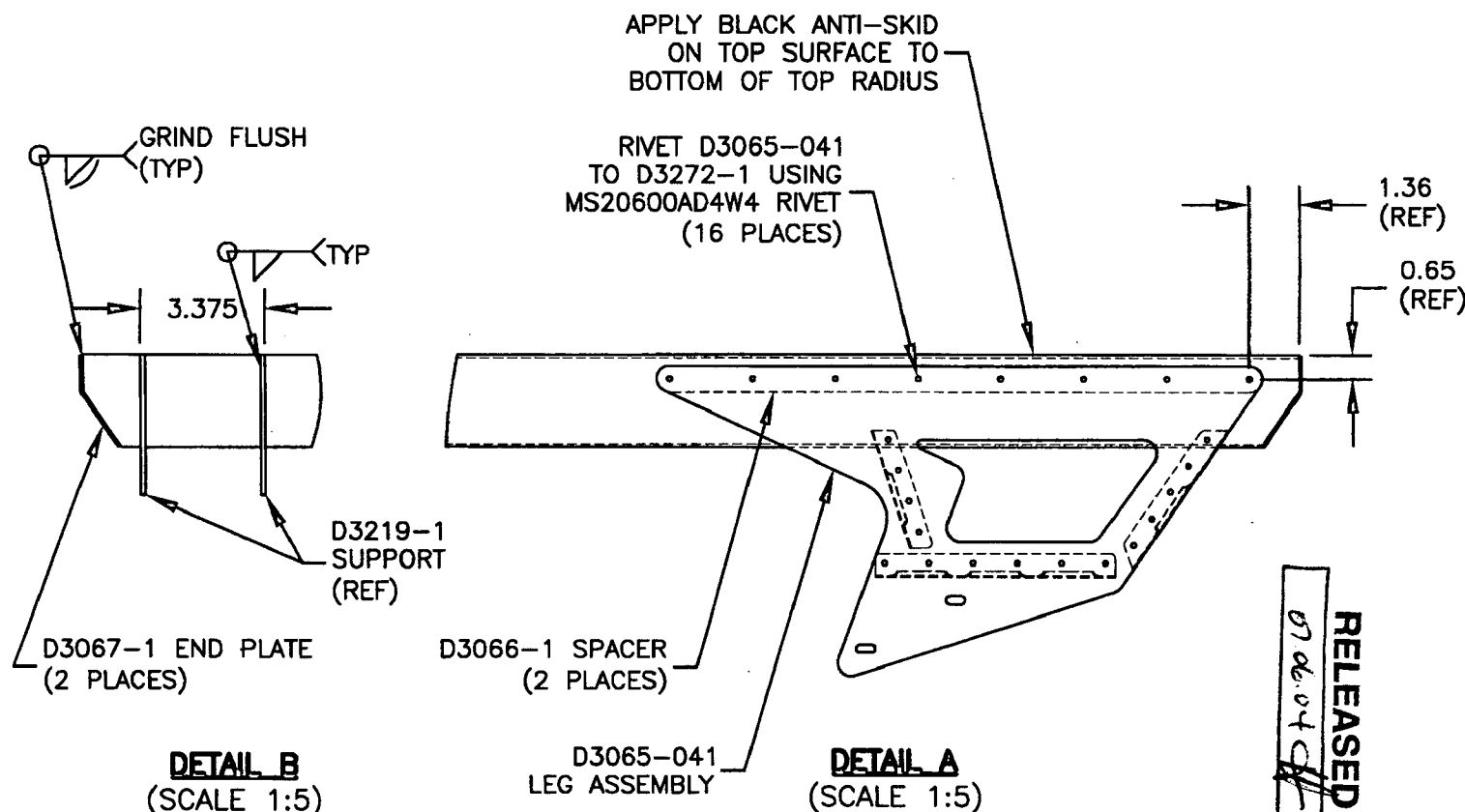
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DESIGN	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	D3272	SHEET 2 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



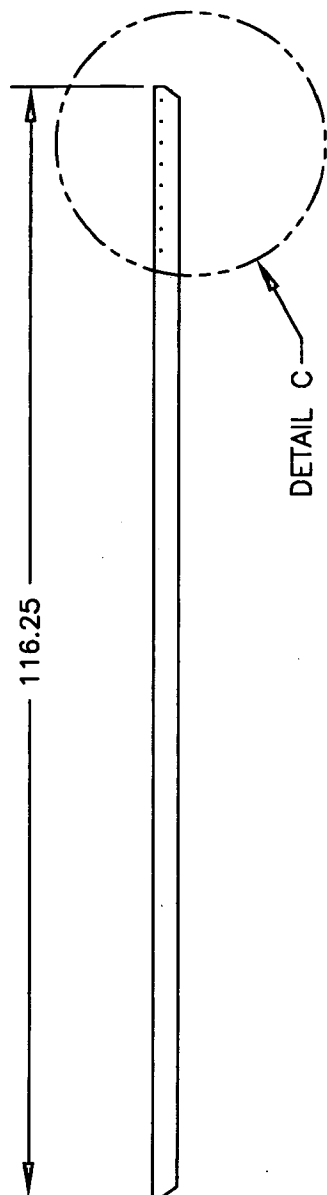
RELEASED
07.06.04



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

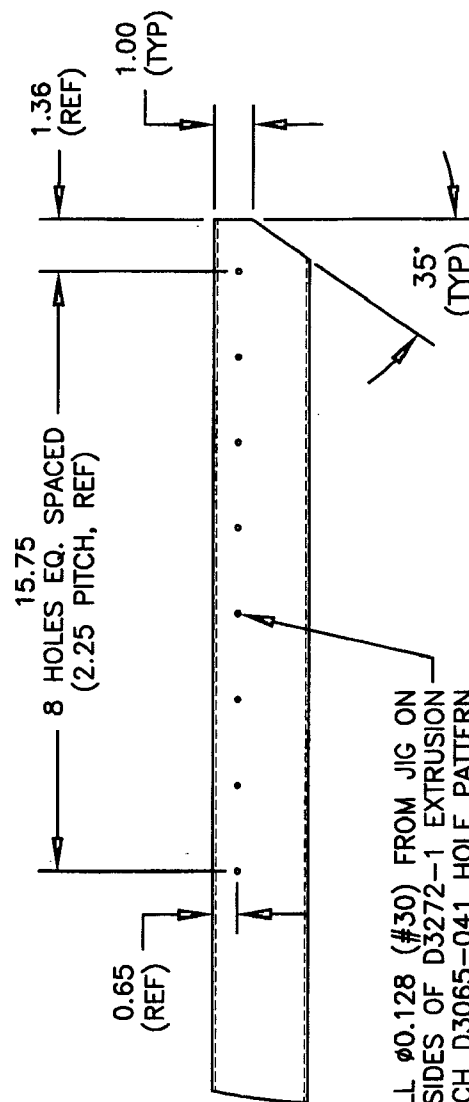
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.